

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003388**Date Inspected:** 17-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yanhua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

Bay 3 – Heavy Duty Machinery Shop

The QA Inspector observed ZPMC qualified welder Dong Hu Yong Cang ID 203805 utilizing (WPS) WPS-345 FCAW-2G (2F)-repair 1 to perform Flux Core Arc Welding (FCAW) to perform ultrasonic lack of penetration repair (LOP) on Partial Joint Penetration (PJP) weld on deck panel DP077-001 weld number 8.

The QA Inspector inventoried a total of 23 deck panels stored inside the machine shop for repair.

The weld repair generally appeared to comply with the weld procedure specification (WPS) WPS-345 FCAW-2G (2F)-repair 1 which was submitted by ZPMC as the LOP repair procedure. The Submittal number is 634R2 Internal Weld Repair Demonstration dated June 11, 2008.

OBG Bay 1

The QA Inspector observed Submerged Arc Welding (SAW) in progress on DP466-001 at Gantry # 1 and SAW welding had been completed on DP333-001.

The QA Inspector observed that DP145-001 had been tack welded and was idle at Gantry # 2 and DP414-001

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(SAW) welding had been completed and the panel was idle.

The QA inspector was informed by the ZPMC CWI Li Yan Hua that ZPMC had performed Magnetic Particle Testing (MT) Inspection on DP466-001 tack welds and one crack was found, DP333-001 had 4 cracks which were removed by grinding.

Summary of Conversations:

As noted within the report shown above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Dixon, Roscoe	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
